

Work Order ID 150488***150488***

Page 1

Wednesday, August 24, 2016 12:38:22 PM

Item ID: D3769-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tube

Start Date: ~~8/19/2016~~ ^{02/24/2017} Start Qty: 2.00Required Date: ~~8/24/2016~~ ^{03/1/2017} Req'd Qty: 2.00Reference: ^{03/1/2017}***2***
2DAS
21
9-89

Cust Item ID:

Customer:

Approvals:

Process Plan:

DAS
21
9-89Date: **AUG 30 2016**

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3769

Rev A

100

0.00

100

Small Fab

Small Fab

Memo

0.08

Small Fab

1-cut tube to length as per dwg D3769-2-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig- deburr

10 0 17-2-24 DAS 19 9-89

110

0.00

110

QC

QC5- Inspect part completeness to step on W/O

Memo

0.01

Quality Control

10 0 FEB 2 6 2017 DAS 38 9-89

120

0.00

120

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.02

Hand Finishing

10 0 2017/02/27 BFB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

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Page 2

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Item ID: D3769-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tube
Start Date: 8/19/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/24/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00				10			DAS 38 9-89
Quality Control									FEB 27 2017
140	Identify as per dwg & Stock Location: <u>St254</u>	0.00							
140									
Packaging	Memo	0.00				10			DAS 6 9-89
Packaging									FEB 28 2017
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.03							17/2/28 J
Quality Control									DAS 21 9-89

FEB 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER :			
Misidentified ☐	☐	Past Due ☐	☐				

Picklist Print

Wednesday, August 24, 2016 12:38:22 PM

Page 1
T

Work Order ID: 150488

150488

Parent Item: D3769-5

D3769-5

Parent Item Name: Tube

Start Date: 8/19/2016

Required Date: 8/24/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-08-27 Drilling Tooling Added JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T1.000W065

Purchased

No

100

f

17.7424

1.6742

3.524632

M6061T6T1 000W065

**

17-2-24

DAS
19
9-89

6061T6 RD TUBE 1.00 x .065w

Location

135565

Loc Qty

15.79997

Loc Code

GA002

X1

M134528

15.79997

MAT

133700

1.942413

M132577

1.942413

X1

136569

13.44

1.68

1.68

DQA: _____ Date: _____

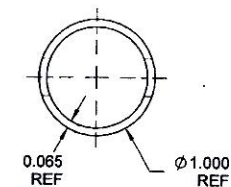
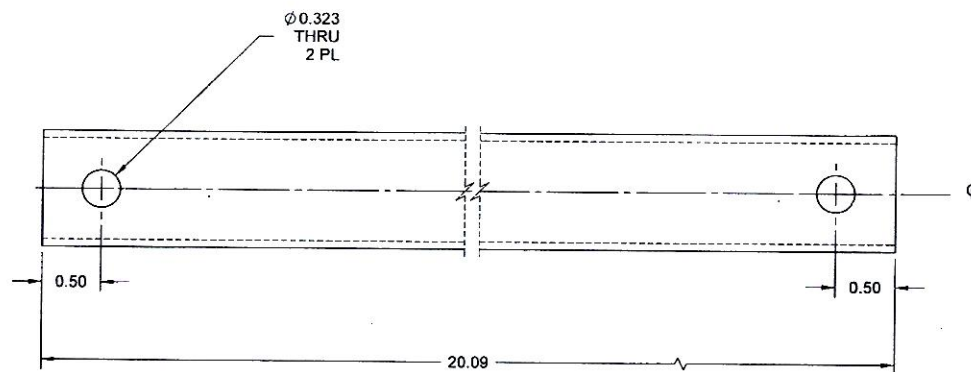
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D3769-5 TUBE

RELEASED
68-06-15

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3769	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED TO YOU ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR LOANED OR OTHERWISE USED BY ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	